

CS - 747 series 削皮机



使用说明书 INSTRUCTION MANUAL

Read safety Instructions carefully and understand them before using.
Retain this Instruction Manual for future reference.

为了安全地使用，请您在使用之前仔细阅读本使用说明书。
另外，请您注意保管本使用说明书，以便随时查阅。



操作手冊 / INSTRUCTION MANUAL

用途:

適用於各種皮革、人造皮、塑料鞋、皮帶、袋子、手套等的削皮及表面打磨。

Function: used for all kinds of skiving leather、artificial leather、plastic shoes、strap、bags、gloves and so on

特點:

(圖一)

- 1). 平面磨邊最大50MM寬度
- 2). 自動除屑裝置
- 3). 除磨刀具
- 4). 部品更換簡便

Merits:

- 1) The max width of plain skiving is 50 mm.
- 2) The automatic waste releasing device.
- 3) The knife grinding tools.
- 4) Easy to change the parts.

規格:

機械尺寸: 530(長)x340(寬)x370(高)mm

馬達轉速: 1,000 ~ 1,200s.p.m.

馬達: 1/3HP=250W

機器重量: 40KGS

Specification:

Mechanism dimension: 530(length) * 340(width) * 370(height) mm

The speed of motor rotating 1000 - 1200 s.p.m

Motor : 1/3 HP=250W

The weight of machine: 40 kgs

注意要點

1. 機器安裝時, 須注意馬達飛輪(外徑75mm - 90mm)與機器飛輪M1105-0A二者的凹溝要成一直線
2. 機器右側的飛輪之回轉方向為順時針方向
3. 新機操作前須先注油潤滑并定期給油(如圖所示各部位)保養, 機器運轉才會良好并保持機器使用年限壽命

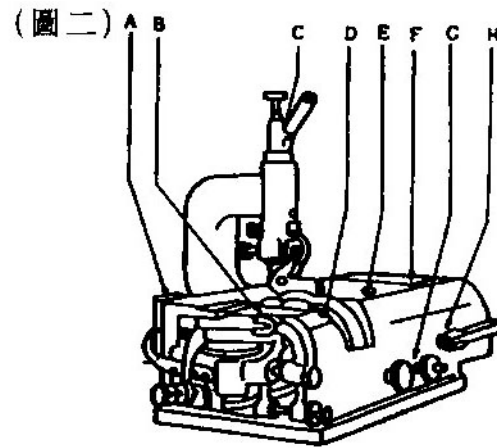
Notice:

1. Keep the groove of motor flywheel(the external diameter 75mm-90mm) and machine flywheel M1105-0A in the beeline.
2. The direction of the machine flywheel turning is clockwise.
3. Before operating the new machine, only if first lubrication(like the picture) and keep maintenance with oil regularly, can the machine operate well and keep longevity.



- A 部位—1個月加油一次
- B 部位—3~4個月加油一次
- C 部位—3~4個月加油一次
- D 部位—3~4個月加油一次
- E 部位—3~4個月加油一次
- F 部位—3~4個月加油一次
- G 部位—3~4個月加油一次
- H 部位—3~4個月加油一次

- A part- lubrication once a month
- B part- lubrication three or four months
- C part- lubrication three or four months
- D part- lubrication three or four months
- E part- lubrication three or four months
- F part- lubrication three or four months
- G part- lubrication three or four months
- H part- lubrication three or four months



4. 更換機臺零件,如削皮刀,送料砂輪,磨刀砂輪,押腳等時,務必關掉電源,確認馬達停止轉動方可進行,以避免不必要的危險.

4. To avoid unnecessary danger, be assure to turn off the power and the stop of the motor when changing the machine parts, like skiving, feed grindstone, grindstone, presser foot etc.

調整運轉

本機器在操作運轉前,務必先確認機器的回轉方向,回轉速及給油等前置動作的完成.

Adjust the movement

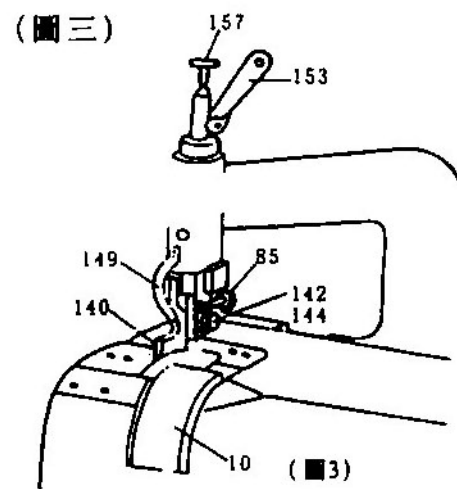
Before operating the machine, be sure the direction and speed of the machine rotating, and lubrication.

押腳的調整

- 1). 押腳大幅度上下操作時,
如圖三所示#153把手須先按下.

The adjustment of the presser foot

- 1) Press the hand knob 153 when operate the presser foot in large extent like the picture 三



2). 押腳調節螺絲#157可以調整

押腳#140須要削皮的量.

物料較薄時,押腳調節螺絲朝右轉

押腳即會下降壓住物料.

物料較厚時,押腳調節螺絲朝左轉

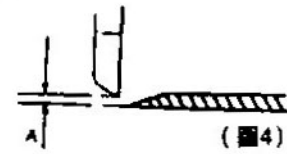
押腳即會上升,讓物料放入再壓住

右圖所示即為押腳上下操作,視物料

厚薄高低的量調整.

通常普通厚物料,押腳與刀鋒邊距約1mm.

(圖四)



2) Adjust the presser foot 140 through turning the screw 157

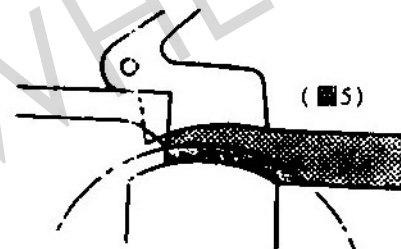
When the materials are thin, turn the screw to the right, the presser foot will decrease to press the materials. When the materials are thick, turn the screw to the left, the presser foot will increase to press the materials. The right picture shows the process of the presser foot operation, adjust the presser foot according to the materials. The clearance between presser foot and the edge of the sharp knife is about 1 mm if it 's the normal materials.

3). 上圖三#85調節螺絲可以調整削皮角度

如右圖五所示,#85調節螺絲左右回轉即可調整押腳的角度.

(圖五)

3) The picture 三# adjust the screw 85 to change the angles of the skiving, like the right picture 五, turn the screw 85 left and right to adjust the angles of the presser foot.



4). 押腳的更替

圖三#153把手板起朝上,#149押腳彈簧板

朝左右板開,松脫#144及#142的固定螺絲,

從缺口方向轉開,即可取下押腳,換好新押腳后反次序做回即可.

(#153把手板上時,#157螺絲上升)

4) The replacement of the presser foot

The picture 三 raise up the hand knob 153, the 149 board of the presser foot spring open from the left and right, loosen the screw 144 and 142, turn to the gap direction and take off the screw at the same time change the new presser foot recovering to the original condition.

(raise up the hand knob 153, the screw 157 rise)

送料砂輪(蛋石)的調整

- 1).送料砂輪#80刀內面成平行(圖六),
其距離(圖七)C則視加工品物料厚薄而定.

The adjustment of feed grindstone

- 1) The internal side of feed grindstone 80 knife is paralleled, which distance with C (picture 七) depends on the process materials.
- 2).間隔C的調整由#92(圖六)調節螺絲調整,向右回轉,間隔大些,向左回轉刀鋒靠近,間隔即小些
- 2) The clearance of C is adjusted by the screw 92 (picture 六), turn the screw to the right, the clearance is big, turn to the left approaching the sharp knife, the clearance is small.
- 3).送料砂輪與刀的距離
薄物約為0.3mm ~ 0.5mm
厚物約為1mm ~ 1.5mm

- 3) The clearance between feed grindstone and knife, the thin material is about 0.3mm-0.5mm, the thick is about 1mm-1.5mm.

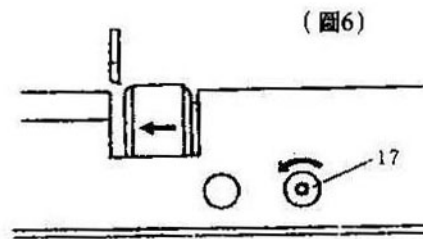
- 4).圖六#85調整螺絲向左右回轉,
可以調整送料砂輪的角度.
如(圖八)所示.

- 4) The adjustment (picture 八) of the feed grindstone angle through turning the screw 85 to the left and right (picture 六)

- 5).加工品物料較硬時,圖六#96土臺腕張力挂金可以調整送料砂輪向上壓力,將其勾到第三格即可將加工品物料夾緊些.加工品物料屬軟性質料時,將#96土臺腕張力挂金勾到第二格或第一格即可.
(#95土臺腕張力彈簧彈力放松)

- 5) When the process materials are tough, picture 六 adjust the roller bracket arm spring hook metal 96 to increase the tension of the feed grindstone, nip the materials tightly through changing it 96 to the third grid. When the process materials are soft, change the roller bracket arm spring hook metal to the second or first grid. (loosen the roller bracket arm spring hook metal).

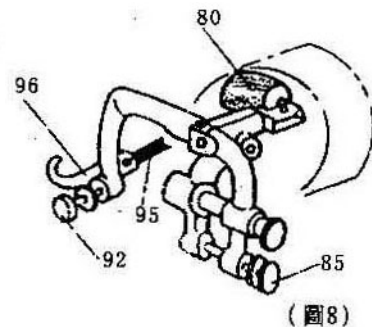
(圖六)



(圖七)



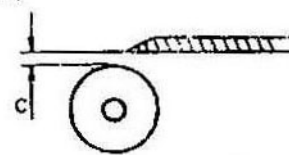
(圖八)



定規的使用

削皮要寬窄的調整如圖九所示間距D。
間距D的調整,松開#9號螺絲,調整#6定規
前進后退至所須尺寸,將#9號螺絲鎖緊
固定,即為間距D的尺寸大小。
滑板#5維持不動。

(圖九)



(圖9)

The use of the

The adjustment of the width and narrow of the skiving like picture 九 through adjusting the clearance D, loosen screw 9, adjust the pole to the proper position, then tighten the screw 9, which is the clearance D, the slide plate keeps stillness.

刀的調整

- 1).磨刀前須先確認調整好押腳與刀鋒的距離。
(圖十所示間距B)

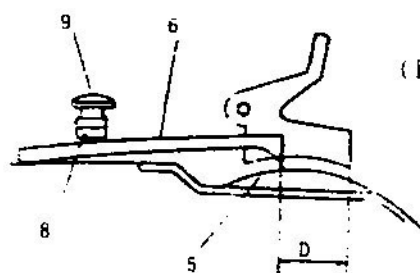
(圖十)



The adjustment of the knife.

- 1) Adjust the clearance between presser foot and sharp knife before grinding knife (picture 十 the clearance B)
- 2).調整圖十一所示#17位置,可以調整刀的前進後退位置。
反時針方向一刀前進(向押腳方向)
順時針方向一刀後退
- 2) Adjust the position of knife like picture 十一 #17, the knife moves forward counterclockwise (towards the presser foot), the knife moves backward clockwise.
- 3).押腳與刀鋒距離B,視加工品物料厚薄而定。
- 3) The clearance B between presser foot and sharp knife depends on the materials.

(圖十一)



(圖11)

刀與磨刀砂輪(白石)的調整

- 1). 將圖十二的#39號扳手朝下壓,
調整#58向左轉,磨刀砂輪向前移并接近刀,
此時磨刀砂輪即可運轉進行磨刀動作.
磨刀動作完成后,調整#58向右轉,磨刀砂輪
即會后退.

The adjustment between knife and grindstone

- 1) Press the knob 39 like picture 十二, turn the 58 to the left, the grindstone moves forward and approach the knife, at this moment the grindstone operates and grind the knife. When the grindstone finished, adjust the 58 to the right, the grindstone moves backward.
- 2). 研磨刀時須注意不要磨太快,磨刀砂輪發熱
反黑或無色彩,刀子的鋼度會快速根掉及不利,
所以不能磨太快.
- 2) Don't grind the knife too sharp, because the grindstone becomes hot and black or colorless, the toughen of the knife becomes dim and sharpless.
- 3). 磨好刀后反次序調整回去即可。
- 3) When finished the grind, adjust back to normal.

洗石

附件箱中的#3Y石虎工具,專用來洗
磨刀砂輪不平的地方,如磨刀砂輪上
夾雜的鐵粉屑等.

Clear the stone

The 3Y tools in the accessories are used for clearing the uneven parts of the grindstone, like the scrap iron in it.

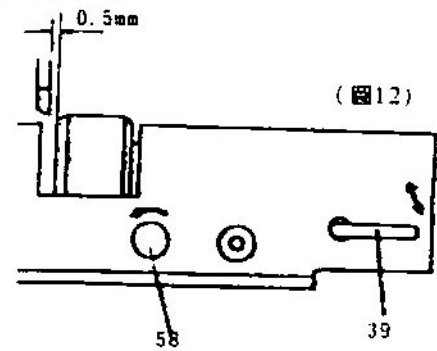
磨刀砂輪的更換

- 1). 用左手持住#50磨刀砂輪,用右手轉動#54
飛輪,反時針方向旋轉.

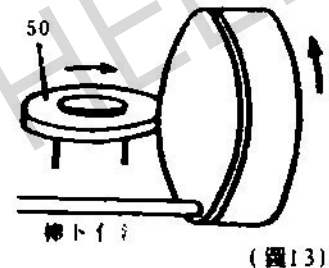
The replacement of the grindstone

- 1) Catch the grindstone 50 with left hand, turn the flywheel 54 with right hand counterclockwise.

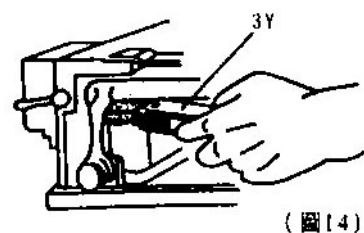
(圖十二)



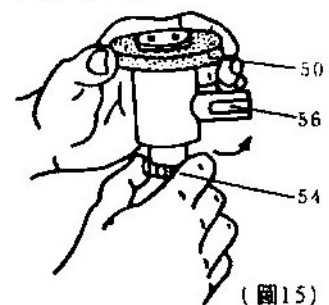
(圖十三)



(圖十四)



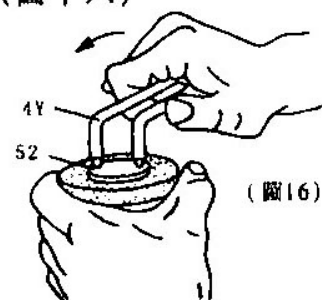
(圖十五)



2). 用附件箱中的#4Y夾子工具,夾住磨刀砂輪上
#52華司墊片,旋轉松開后即可取出磨刀砂輪.

2) Clip the washer 52 on the grindstone with clip 4Y
in the accessories and turn and loose it, then take
the grindstone out.

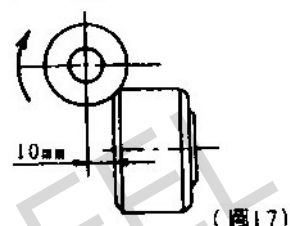
(圖十六)



3). 換好磨刀砂輪后依反次序裝回調整即可.
但須注意:磨刀砂輪的中心與刀鋒的距離
約10mm(圖十七)磨起來刀口角度才會鋒利.

3) Install them to normal after changing the
grindstone. But notice: the edge of the knife
which is grinded is the most tartness only when
the clearance between the center of the
grindstone and the blade is about 10MM(like
picture 十七).

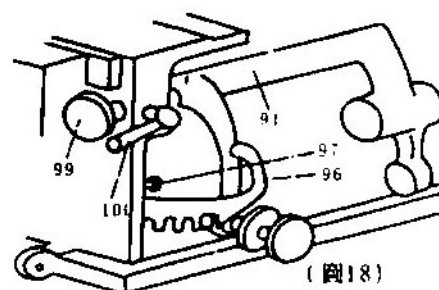
(圖十七)



送料砂輪的更換

- 1). 將土臺腕張力挂金勾到#97位置
- 2). 將#99向后拉出,#100螺絲拆松,
#91土臺腕即可取出
- 3). 將圖十九的S147拆松,#81及#80
送料砂輪拉出即可替換.
- 4). 換好送料砂輪后依反次序裝回調整
即可.

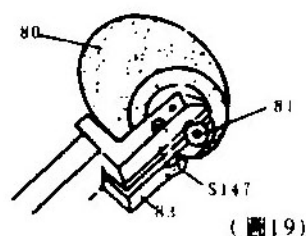
(圖十八)



The replacement of the feed grindstone

- 1) Move the roller bracket arm spring hook metal
to the 97 position
- 2) Pull the 99 backward, loosen the screw 100,
then take out the 91
- 3) Loosen the S 147 of picture 十九, then replace
the feed grindstone when they 81&80 are
pulled out.
- 4) Install and adjust them to normal after
replacing them.

(圖十九)



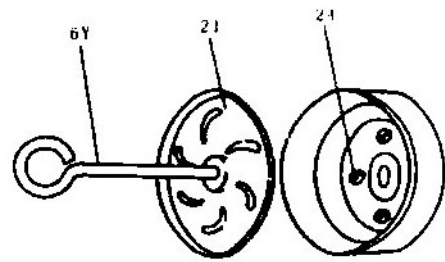
刀子的更換

更換刀子時,圖十八裏的零件須先拆卸下來,
刀子退至最底端.

用#6Y工具插入#21皮屑排出板將其拆下
松開#24固定刀螺絲(共4個)即可更換刀子,
換好刀后反次序裝回即可.

*注意:固定刀的4個螺絲要壓力一致,
刀子在運轉時才不會振動,新換刀子操
作時要先給油.

(圖二十)



(圖20)

The replacement of the knife

Before replacing the knife, the parts are knocked down in the picture 十八, and the knife returns to the lowest end.

Knock down the plate of scurf debaring 21# with 6Y tool, loosen the screws(4 pieces) of fixed knife 24#, then replace the knife and install back to normal again.

*notice: only if the pressure of the four screws on the fixed knife should be balanced, the knife will not quiver when it is moving, lubricate first before operation when the knife is new.

滑塊膠套的更換

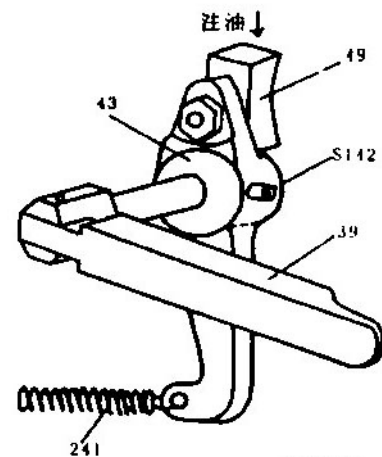
將#241彈簧放鬆,#S142松開,#39控制刀子運轉的開關撥出,#43取出,#49滑塊膠套即可更換.
此部位因磨損率較高,適時加油可以延長使用期間.

Replace the rubber cover of clutch slide block

Loosen the spring 241#, 142#, control the switch of the knife moving, take out 43#, then replace the rubber cover of clutch slide block.

This part is easy to fret, so always lubricate to extend its longevity.

(圖二十一)



(圖21)

安全斷電保護裝置 (CS-747E)

- 1) 安全斷電保護裝置（帶蜂鳴器）系安裝于臺板下電源開關電路與馬達驅動器電路之間的一個斷電安全裝置。

Power protection device (CS-747E)

- 1) A power protection device (with a buzzer) is a power cut-off device installed between switch and motor driver below the bedplate.

2. 當被安裝安全微動開關的可拆卸的蓋板被拆卸時，安全微動開關立即起保護作用，使驅動馬達停止工作（此時蜂鳴器鳴叫）

- 2) The micro-switch will immediately protect the device by stopping the motor driver (buzzer alerting) when the removable cover plate is taken apart from the micro-switch.

- 3) 模式切換開關

有效模式（鑰匙可以拿下）：安全微動開關保護啟動

無效模式（鑰匙不可以拿下）：安全微動開關不可工作，安全保護失效。

- 3) Mode transfer switch.

Effective mode (key removable): micro-switch activated to protect.

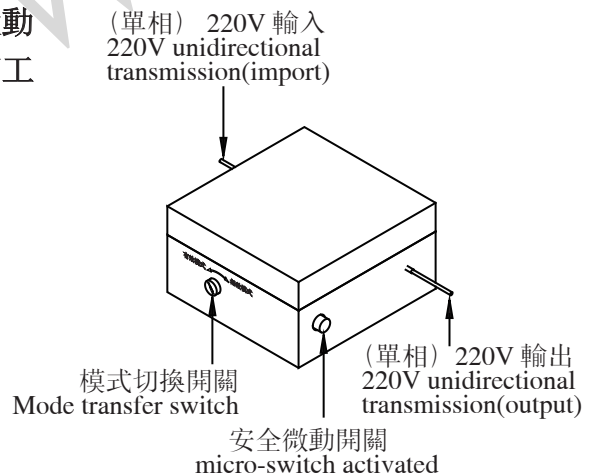
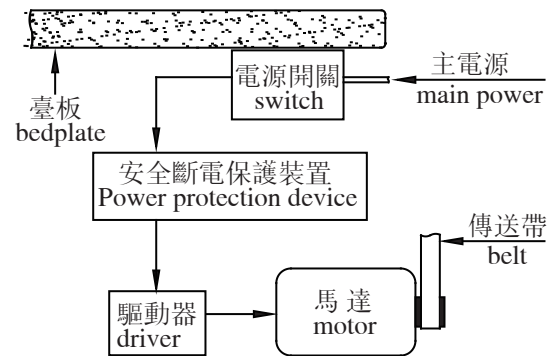
Ineffective mode (key irremovable): micro-switch not working to protect.

- 4) 電源：單相220V

電流：5A以下

- 4) Power: 220V unidirectional transmission.

Current: $\leq 5A$.



GOLDEN WHEEL

啓翔股份有限公司

CHEE SIANG INDUSTRIAL CO.,LTD.

NO.32 WU CHUAN 7TH ROAD, WU KU INDUSTRIAL AREA,
WU KU HSIANG 24248, TAIPEI HSIEN, TAIWAN.

